

Work Order ID 66758

Friday, February 25, 2011 1:24:13 PM



Page 1

Item ID: D350-636-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube LH

Start Date: 2/25/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN-D350-636

H

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-011 CHG 006

11 04 14 17

B66758

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00



Skidtubes

0.00

Skidtubes

Memo

Skidtubes

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill jig DT8150 & DT8863A for first side only DT8863B for second side (detail B)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.
SECOND SIDE

8-Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail C to 0.500" (8 holes per side)

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

JB

11/03/21

W/O:		WORK ORDER CHANGES					
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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left
from bending as per QSI 004
A/R Aluminum Rod batch: M116577

12-Grind welds flush as per Dwg D2750

BE 11/03/22

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

8 w/03/22

Memo

0.00

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8 w/03/22

Memo

0.00

FD

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



HandFinish

Memo

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

(1)

BB

11/03/25

150



QC

Memo

Quality Control

QC3- Inspect Part Finish

0.00

0.00

1 0 BE 11/03/25

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

0.00



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R ☐☐☐ Sikaflex-291 batch: M116090 ☐☐
exp. date: 09/2011

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 8)

A/R ☐☐☐ Aluminum Rod batch: M116577

9- At section AJ-AJ drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

BE 11/03/25

BE 11/03/31
BE 11/03/31
BE 11/04/01

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp11-Spot face ground handling holes section (total of 4 places per side) as per
dwg D2750

BE 11/04/01

12-Deburr holes

BE 11/04/01

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

S 11/04/01

Memo

0.00

QC5- Inspect part completeness to step on W/O

0.00

S 11/04/01

Memo

0.00

180



QC

Quality Control

(to)

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 HandFinish	Pressure Wash per QSI005 4.3	0.00				1	0	11104/06	
Hand Finishing	Memo ✓ Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.	0.00							
200 Powdercoat	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				1		BL 11-4-5.	
Powder Coating	Memo START TIME: 8:25 OVEN TEMPERATURE: 320° FINISH TIME: 8:55	0.00							
210 QC	QC3- Inspect Part Finish	0.00				1	0	11104/05	
Quality Control	Memo ✓ Inspect for foreign object per QSI 024	0.00							

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

220



HandFinish

HandFinishing

0.00

Memo

0.00

Hand Finishing

1- Install inserts as per Dwg D2750

1 0 11/04/05

230



HandFinish

HandFinishing

0.00

Memo

0.00

Hand Finishing

Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3" batch: N/A

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: M1116040EXP DATE: 11/05

4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: M11141895-Coat all exposed fasteners with "LPS Procyon" batch: M1114596

1 0 11/04/05

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00



8 11/6/10

0.00

QC

Memo

Quality Control

250

Pick Kit

0.00



0.00

Packaging

Memo

Packaging

260

QC4- 100% Inspect kits for completeness

0.00



0.00

QC

Memo

Quality Control

*****ensure antiseize is on AN8C21A bolts*****

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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Package as per PPP D350-636-011								
			Rev I	L 72			11/4/14		
280	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/4/15

MF

11-04-14

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

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Parent Item: D350-636-011

Parent Item Name: Skidtube LH



Start Date: 2/25/2011

Required Date: 3/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC
 IPP Rev: M 08-04-22 update steps 4, 13 DD verified by: EC
 IPP Rev: N 08-09-23 revF as per dwg DD verified by: ec
 IPP Rev: O 09-02-06 apply antiseize on AN8C21A bolts as per PAR09-010
 DD verified by: EC IPP Rev: P 10.06.22
 revise seq110 DD verf: EC IPP Rev: Q 10.10.01 as per IIN
 revH DD verf: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2594-3 		Manufactured	No			230	Each	1,031.000	8	8			

O-Ring, 205 Skidtube

Location	Loc Qty	Loc Code
FP	543	
55546	19	
58191	12	
59358	12	
65518	500	
fpa	488	
61762	488	

AN960JD816

Purchased

No

250

Each

89.0000

2

2



1/2" washer, Alum

Location	Loc Qty	Loc Code
ST348	89	
106043	89	

Handwritten initials and marks.

Handwritten: 11/04/05

Handwritten: x8

Handwritten signature and date 11/4/11.

Handwritten: 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Required Date: 3/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2744
Cap

Manufactured No

110 Each

55.0000

1 1



BE 1/03/22

Location Loc Qty Loc Code

LG 29

65086 29

ST 26

62715 26

D2600-3-BENT

Manufactured No

110 Each

6.0000

1



Extrusion Bent

Location Loc Qty Loc Code

LG 6

61634 2

62764 1

64434 3

D2743

Manufactured No

160 Each

122.0000

8

8



Crossbolt Spacer

Location Loc Qty Loc Code

LG 122

50281 10

57953 2

59111 10

61844 16

64003 84

BE 1/03/31

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Start Date: 2/25/2011

Required Date: 3/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2739 Manufactured No 160 Each 4.0000

 350 I Beam

1 1



BE 11/03/25
 B 66981 x1

Location

Loc Qty


Loc Code

LG

4

64448

4

D3490-3 Manufactured No 160 Each 35.0000

 Cross Bolt Spacer

4 4



BE 11/03/31

Location

Loc Qty

Loc Code

LG

35

60294


1

63556

24

64006

10

D3490-1 Manufactured No 160 Each 61.0000

 Cross Bolt Spacer

4 4



BE 11/03/31

Location

Loc Qty

Loc Code

LG

61

59424


3

62450

48

64005

10

ALS4-1032-225 Purchased No 220 Each 3,945.000

 Insert

38 38



11/04/05

Location

Loc Qty

Loc Code

PK011

3945

110768

3945

x38

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Start Date: 2/25/2011

Required Date: 3/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3492-041

Manufactured No

230

Each

93.0000

8

8



Plug Assembly



Handwritten: 11/04/05

Location

Loc Qty

Loc Code

FP013

93

Handwritten: 066937

59114

1

Handwritten: x4

62210

3

63994

29

Handwritten: x4

65068

60

D3793-3

Manufactured No

230

Each

20.0000

1

1



Wearshoe



Handwritten: 11/04/05

Location

Loc Qty

Loc Code

FP018

15

39479

1

39812

2

64447

12

FP18

4

61711

4

FP19

1

57947

1

Handwritten: x1

AN8C35A

Purchased No

230

Each

61.0000

1

1



BOLT



Handwritten: 11/04/05

Location

Loc Qty

Loc Code

ST345

25

116874

25

ST346

36

114442

5

115188

5

115960

26

Handwritten: x1

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, February 25, 2011 1:24:22 PM

Work Order ID: 66758



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 2/25/2011

Required Date: 3/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3793-1

Manufactured No

230 Each

25.0000

1

1



Wearshoe



HL 11/04/05

Location

Loc Qty

Loc Code

FP018

17

39277

1

39715

2

64445

14

FP18

8

59151

1

59630

1

61710

6

XL

D3488-041

Manufactured No

230 Each

17.0000

1

1



Blade Fitting Assembly, LH



HL 11/04/05

Location

Loc Qty

Loc Code

FG008

10

62002

10

XL

FP18

7

61689

7

D3794-3

Manufactured No

230 Each

19.0000

1

1



Gasket



HL 11/04/05

Location

Loc Qty

Loc Code

FP010

3

39422

3

FP10

15

60826

1

61712

14

FP18

1

59153

1

XL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, February 25, 2011 1:24:22 PM

Page 6

Work Order ID: 66758

Parent Item: D350-636-011


Parent Item Name: Skidtube LH

Start Date: 2/25/2011


Required Date: 3/11/2011

Start Qty: 1.00


Required Qty: 1.00

AN6C44A Purchased No 230 Each 97.0000 4 4

 BOLT

Location	Loc Qty	Loc Code
FG	2	
103964	2	
ST344	95	
111649	2	
114653	1	
115936	42	
<u>116874</u>	50	

MS21083C8 Purchased No 230 Each 43.0000 1 1

 NUT

Location	Loc Qty	Loc Code
ST303	43	
113845	5	
114934	3	
115594	4	
<u>115884</u>	31	

D3536-25 Manufactured No 230 Each 24.0000 1 1

 Gasket

Location	Loc Qty	Loc Code
FP	12	
65903	12	
FP12	9	
<u>64446</u>	9	
FP-12	3	
39234	3	

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, February 25, 2011 1:24:23 PM

Page 7

Work Order ID: 66758

Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 2/25/2011

Required Date: 3/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3631-1 Manufactured No 230 Each 144.0000 8 8

Washer  all 11/04/05

Location

Loc Qty

Loc Code

ST072

144



1366959

x4

63647 *

144

x4

D3791-1 Manufactured No 230 Each 14.0000 1 1

Wearplate  all 11/04/05

Location

Loc Qty

Loc Code

FP017

3

39276

1

39418

2



FP17

11

62239

11

x1

AN960C10L NAS1149C0332 Purchased No 230 Each 127.0000 38 38

washer  all 11/04/05

Location

Loc Qty

Loc Code

ST245

127

M116301



x38

107534

59

108246

68

D2745 Manufactured No 230 Each 121.0000 8 8

Bushing  all 11/04/05

Location

Loc Qty

Loc Code

ST023

121

52311

5

59112

4

61988

4

63315

108

x8

Friday, February 25, 2011 1:24:23 PM

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Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, February 25, 2011 1:24:23 PM

Page 8

Work Order ID: 66758

Parent Item: D350-636-011


Parent Item Name: Skidtube LH

Start Date: 2/25/2011


Required Date: 3/11/2011

Start Qty: 1.00


Required Qty: 1.00

AN3C5A Purchased No 230 Each 1,024.000 34 34

 Bolt

Location	Loc Qty	Loc Code
ST350	1024	
107862	68	
108302	34	
114330	11	
115015	13	
115371	4	
115422	100	
115835	194	
116419	500	V34
116549	100	

D3537-1 Manufactured No 230 Each 33.0000 3 3

 Wearpad

Location	Loc Qty	Loc Code
FP017	33	B65927
37749	6	X3
65057	27	

AN960C816L Purchased No 230 Each 0.0000 1 1

 WASHER X NAS1149C08332R / M1114915 (x1) JH 11/04/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 9

Work Order ID: 66758

Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 2/25/2011



Required Date: 3/11/2011

Start Qty: 1.00



Required Qty: 1.00

D3492-043 Manufactured No 230 Each 41.0000 8 8

 Plug Assembly  all 11/04/05

Location	Loc Qty	Loc Code
FP	2	B66931
54682	2	v8
FP013	39	
59117	1	
59190	4	
63996	2	
65070	32	

AN3C6A Purchased No 230 Each 359.0000 4 4

 BOLT  all 11/04/05

Location	Loc Qty	Loc Code
ST351	359	
111982	134	v4
116419	75	
116549	50	
116704	100	

NAS1611-013 Purchased No 230 Each 248.0000 8 8

 O-RING  all 11/04/05

Location	Loc Qty	Loc Code
FP	248	
115460	100	1117291
115589	28	v8
115812	20	
116582	100	

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Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, February 25, 2011 1:24:23 PM

Work Order ID: 66758

Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 2/25/2011



Required Date: 3/11/2011

Start Qty: 1.00



Required Qty: 1.00

D3535-25 Manufactured No 230 Each 21.0000 1 1

 Wearshoe
 xl 4/04/05



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP18	21	
38867	1	
39716	2	
62233	6	
<u>65167</u>	12	<u>yl</u>

D3794-1 Manufactured No 230 Each 15.0000 1 1

 Gasket
 xl 4/04/05

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP010	15	
39279	1	
39421	2	
<u>61704</u>	12	<u>yl</u>

MS21043-6 Purchased No 230 Each 546.0000 4 4

 NUT
 xl 4/04/07

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST301	546	
<u>112314</u>	546	<u>xl</u>

D3493-1 Manufactured No 250 Each 32.0000 2 2

 Washer
 11/4/14

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST062	32	
<u>62677</u>	32	<u>2</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, February 25, 2011 1:24:24 PM

Work Order ID: 66758

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 2/25/2011

Required Date: 3/11/2011

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

43.0000

2

2



NUT



M117291

Location

Loc Qty

Loc Code

ST303

43

113845

5

114934

3

115594

4

115884

31

AN8C21A

Purchased

No

250

Each

71.0000

2

2



BOLT



Location

Loc Qty

Loc Code

ST345

71

113558

1

114653

2

115723

8

116381

60

D3672-1

Manufactured

No

230

Each

1,077.000

8

8



Phenolic Washer



PTO =>

Location

Loc Qty

Loc Code

ST077

1077

42329

10

52505

67

64177

1000

W/O: 66758		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/04/05	230	Assemble with WAS 1515 H3L / M113362	SM	11/04/05	1		MM 11 04 15

Part No: D350-636-011 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, February 25, 2011 1:24:24 PM

Work Order ID: 66758

Parent Item: D350-636-011

Parent Item Name: Skidtube LH



Start Date: 2/25/2011

Required Date: 3/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2741
Blade, 350 Skidtube

Manufactured No

250 Each

79.0000



1

1

11/4/14

Location

Loc Qty

Loc Code

ST466

79

60210

6

61341

33

63589

40

1

D3532-1
Spacer

Manufactured No

250 Each

31.0000



2

2

11/4/14

Location

Loc Qty

Loc Code

ST065

31

62218

31

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

4

3

2

1

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1			D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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WORK ORDER
NO. 46758
PL 11-0225

RELEASED
46758

F	INCORPORATE DSI 9413: QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCK 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS, ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PL	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	PL		
CHECKED	ALP	DRAWING NO.	REV. F
MFG. APPR.	ALP	D2750	SHEET 1 OF 11
APPROVED	ALP	TITLE	SCALE
DE APPR.	ALP	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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7

6

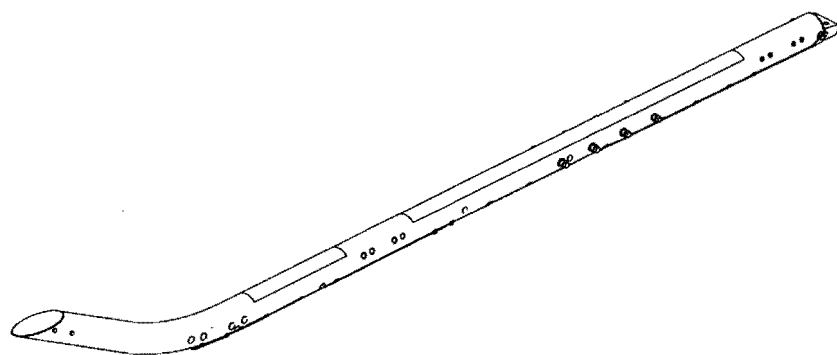
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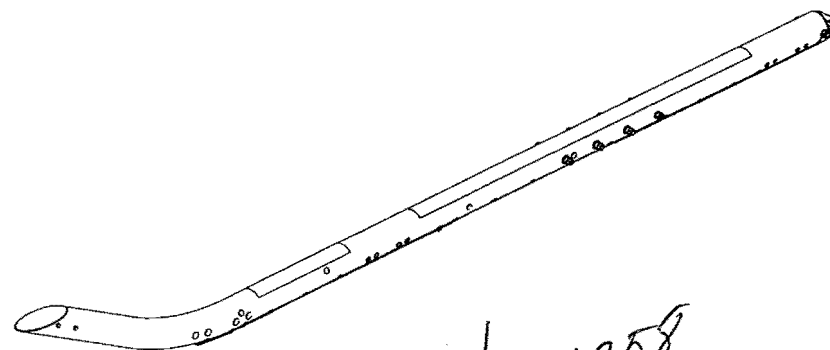
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1



D2750-041 350 SKIDTUBE ASSEMBLY, LH

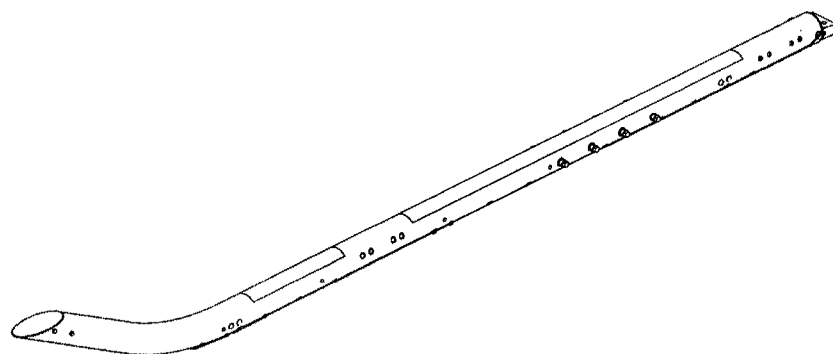


D2750-042 350 SKIDTUBE ASSEMBLY, RH

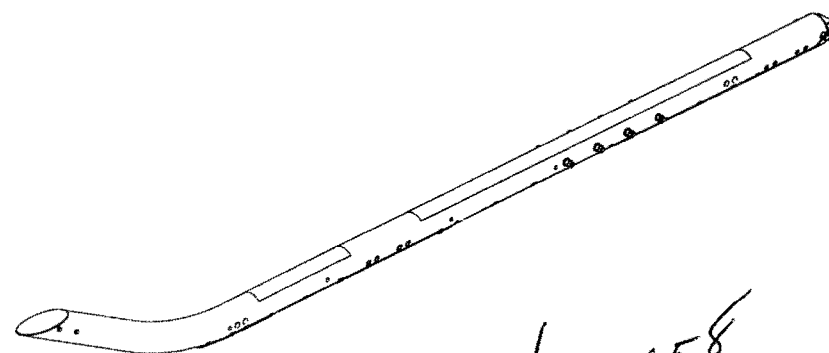
alc 66758

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15 APR 1974

DESIGN	PM	DART AEROSPACE USA, INC.	
DRAWN	PM	PORT HADLOCK, WA	
CHECKED	SA	DRAWING NO.	REV. F
MFG. APPR.	SA	D2750	SHEET 2 OF 11
APPROVED	ME	TITLE	SCALE
DE APPR.	SA	350 SKIDTUBE ASSEMBLY	NTS
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D2750-043 350 SKIDTUBE ASSEMBLY, LH

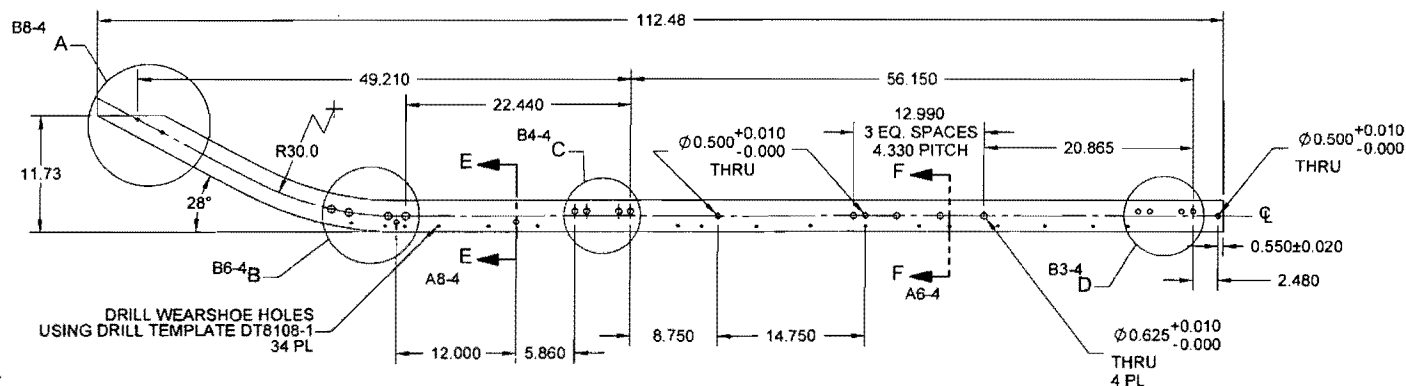


D2750-044 350 SKIDTUBE ASSEMBLY, RH

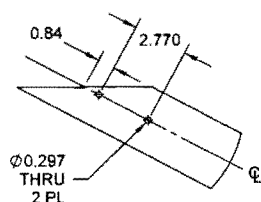
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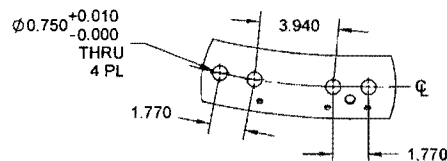
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DRAWN	Red	PORT HADLOCK, WA	
CHECKED	Red	DRAWING NO.	REV. F
MFG. APPR.	Red	D2750	SHEET 3 OF 11
APPROVED	Red	TITLE	SCALE
DE APPR.	Red	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



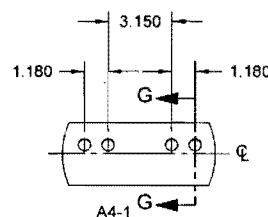
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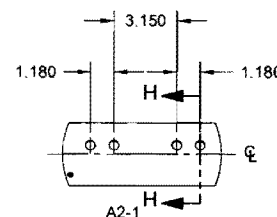
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SCALE 2X



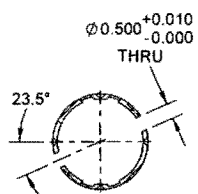
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SCALE 2X



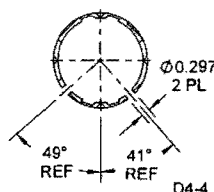
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SCALE 2X



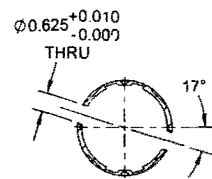
DETAIL D
SCALE 2X



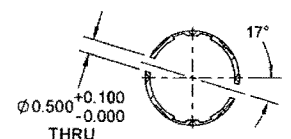
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



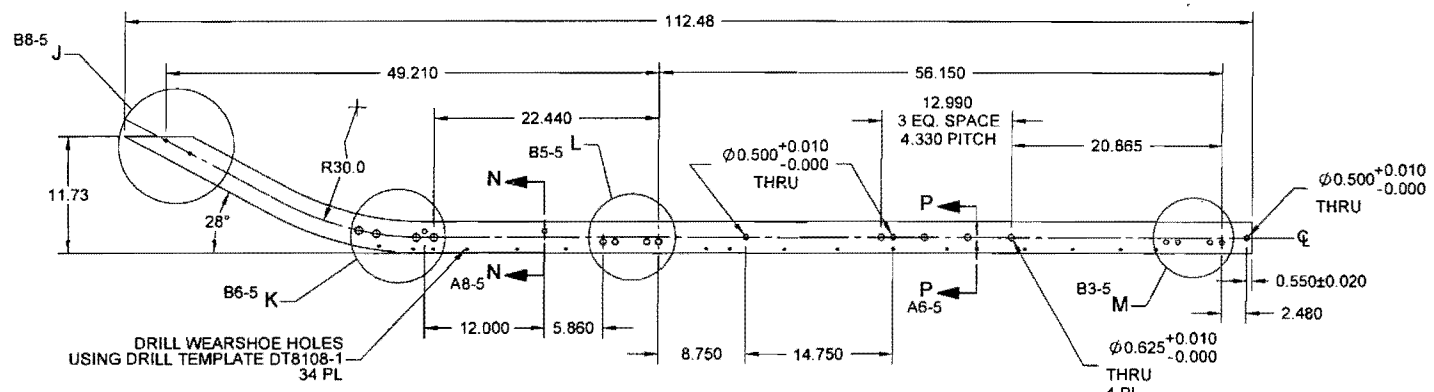
SECTION H-H
SCALE 3X, 4 PL

W/666758

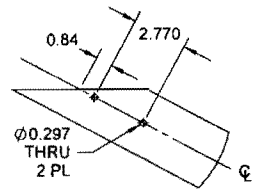
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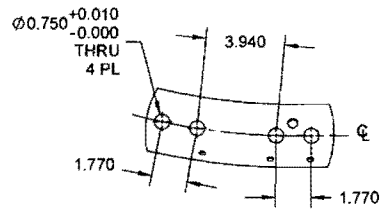
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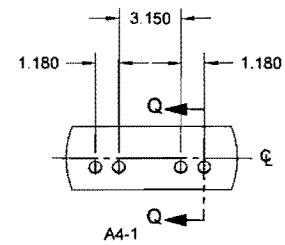
D2750-2 RH SKIDTUBE



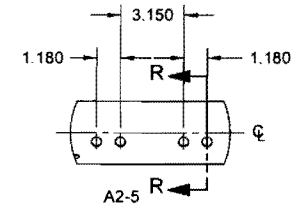
DETAIL J
SCALE 2X



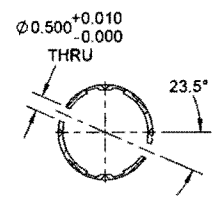
DETAIL K
SCALE 2X



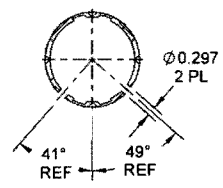
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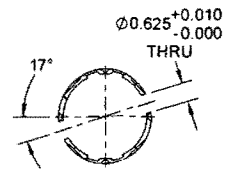
DETAIL M
SCALE 2X



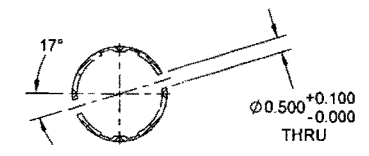
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



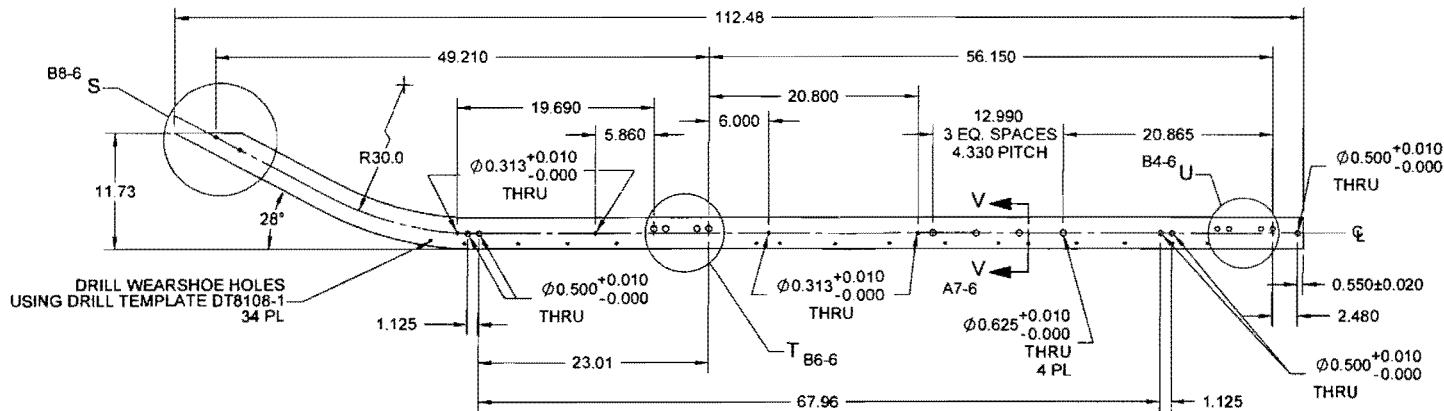
SECTION R-R
SCALE 3X, 4 PL

w/ 66755

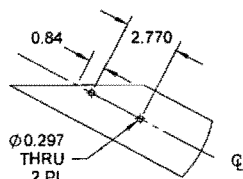
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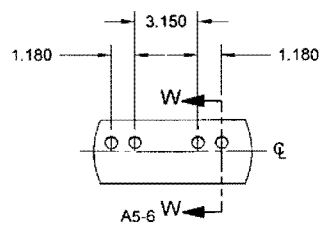
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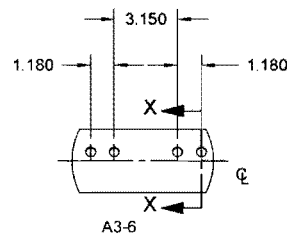
D2750-3 LH SKIDTUBE



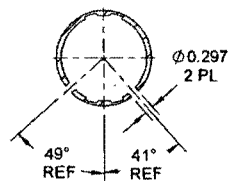
DETAIL S
SCALE 2X
D8-6



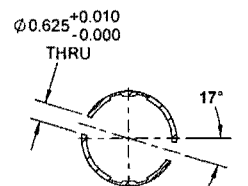
DETAIL T
SCALE 2X
C5-6



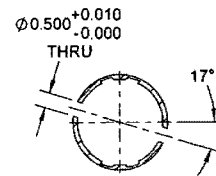
DETAIL U
SCALE 2X
D3-6



SECTION V-V
SCALE 3X, 17 PL
C4-6



SECTION W-W
SCALE 3X, 4 PL
B6-6

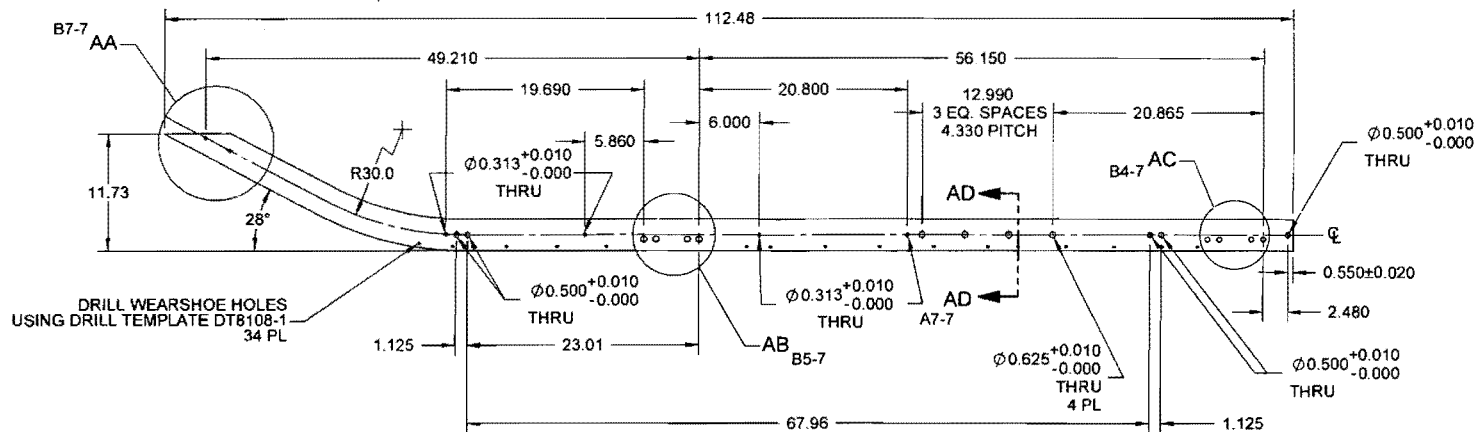


SECTION X-X
SCALE 3X, 4 PL
B4-6

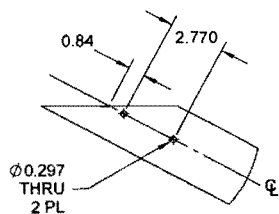
w/o 44755

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08-12-11

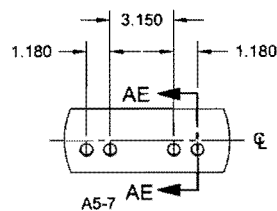
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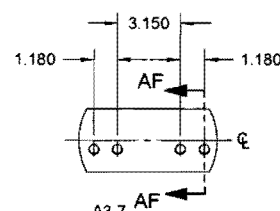
D2750-4 RH SKIDTUBE



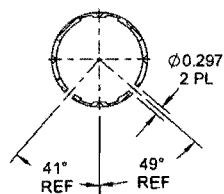
DETAIL AA
SCALE 2X



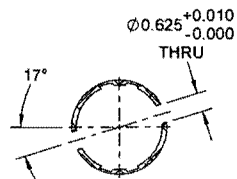
DETAIL AB
SCALE 2X



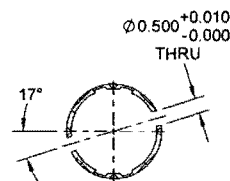
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL

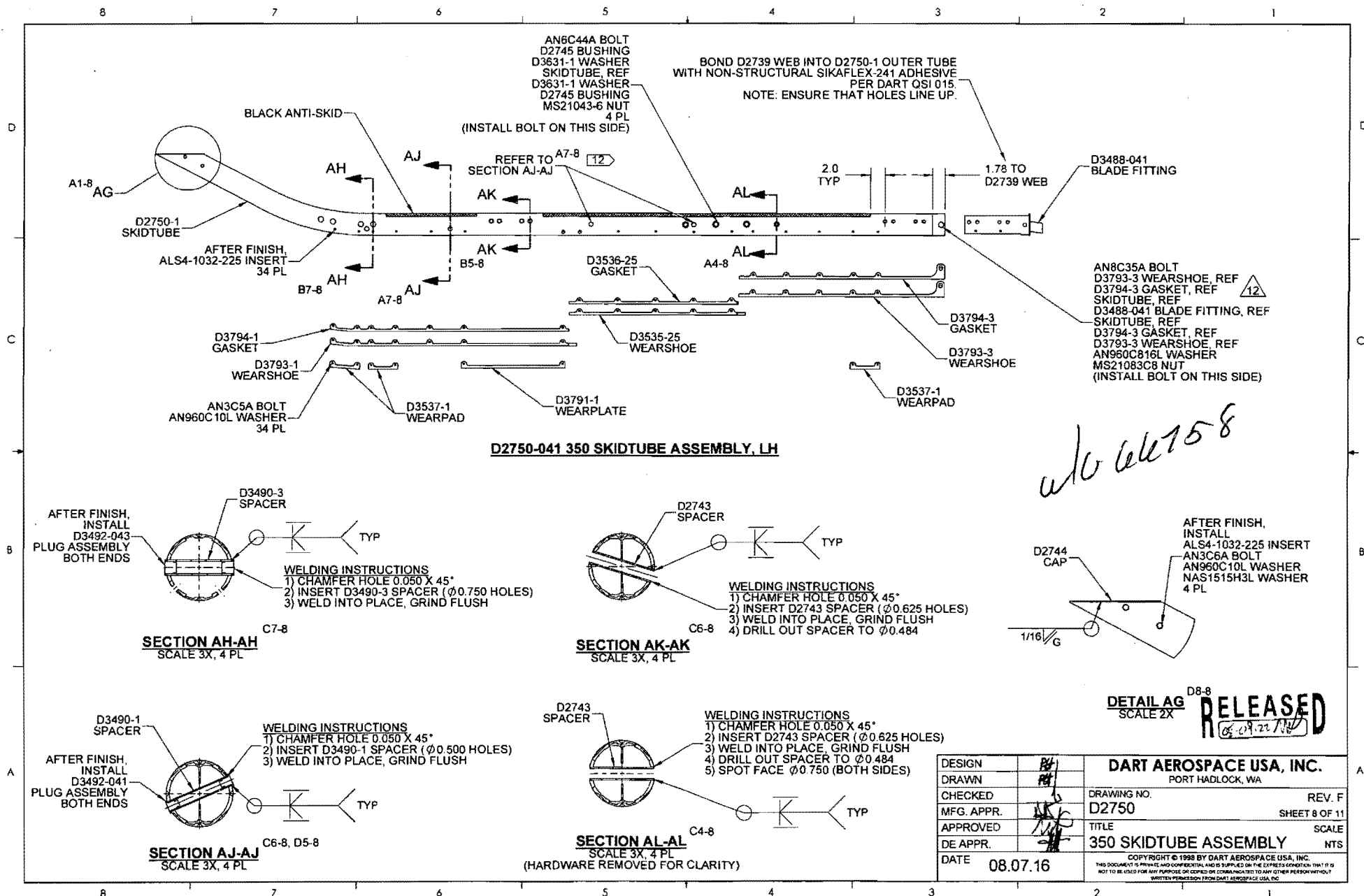


SECTION AF-AF
SCALE 3X, 4 PL

calc 2758

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8

7

6

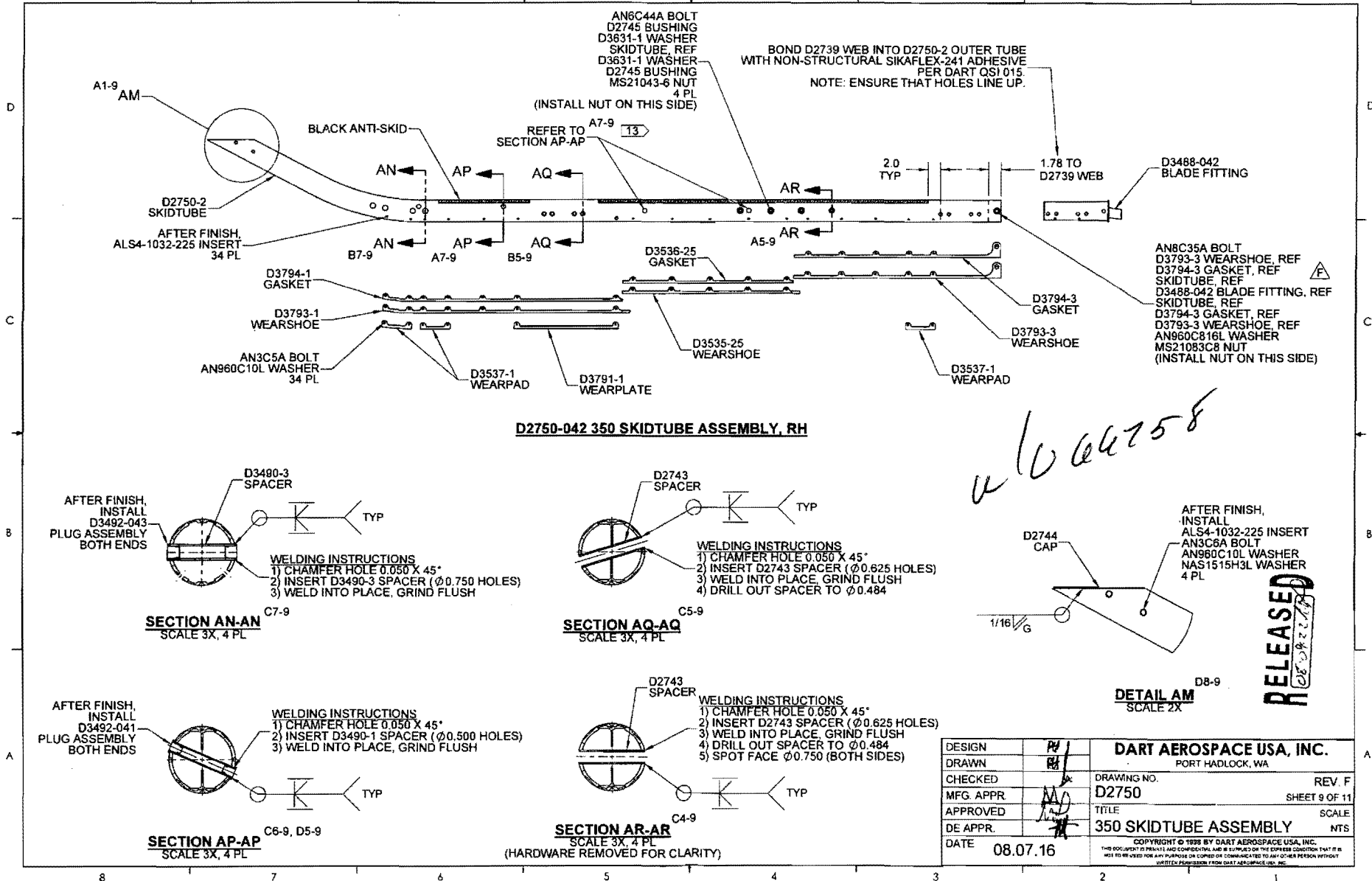
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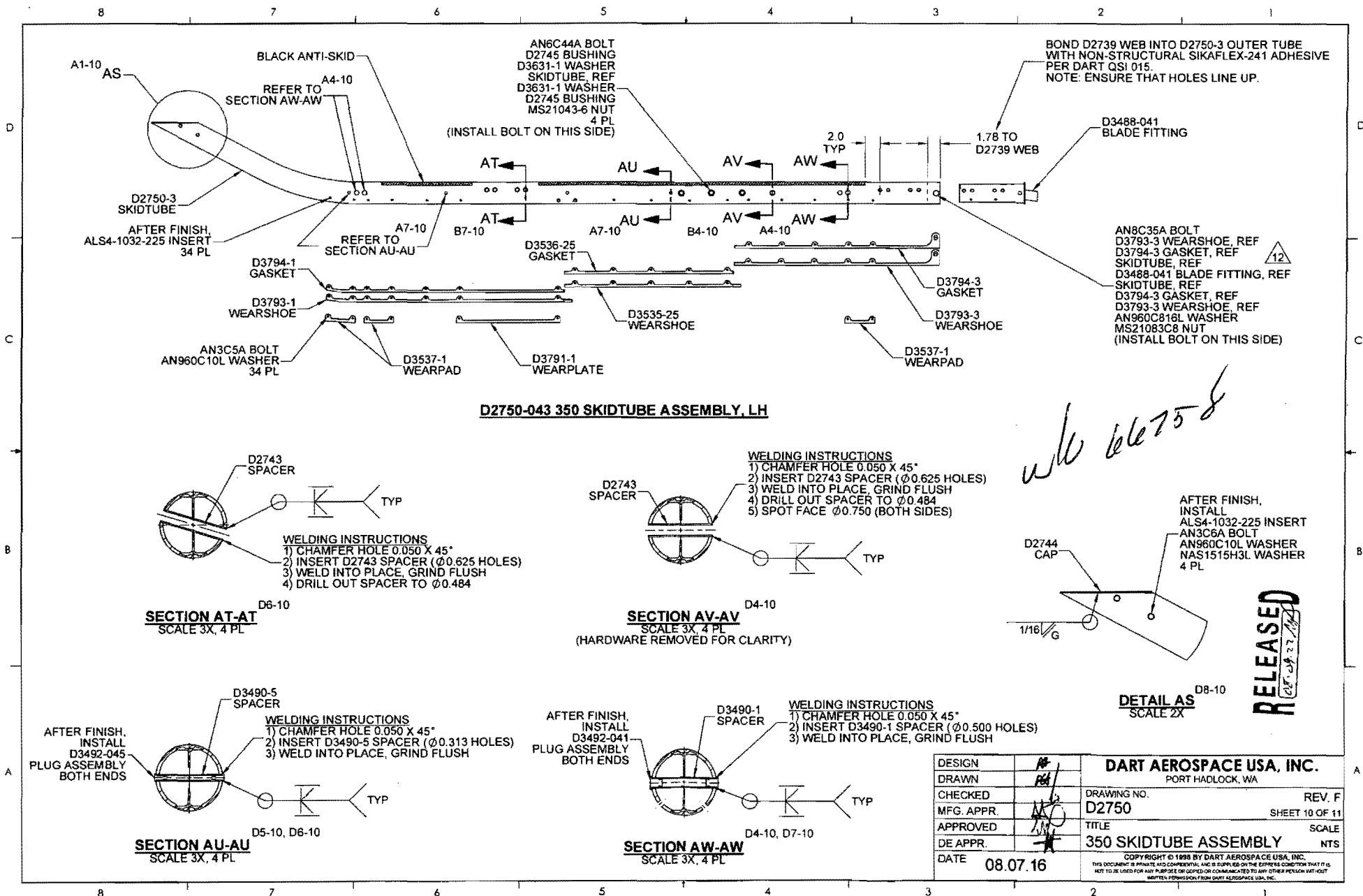
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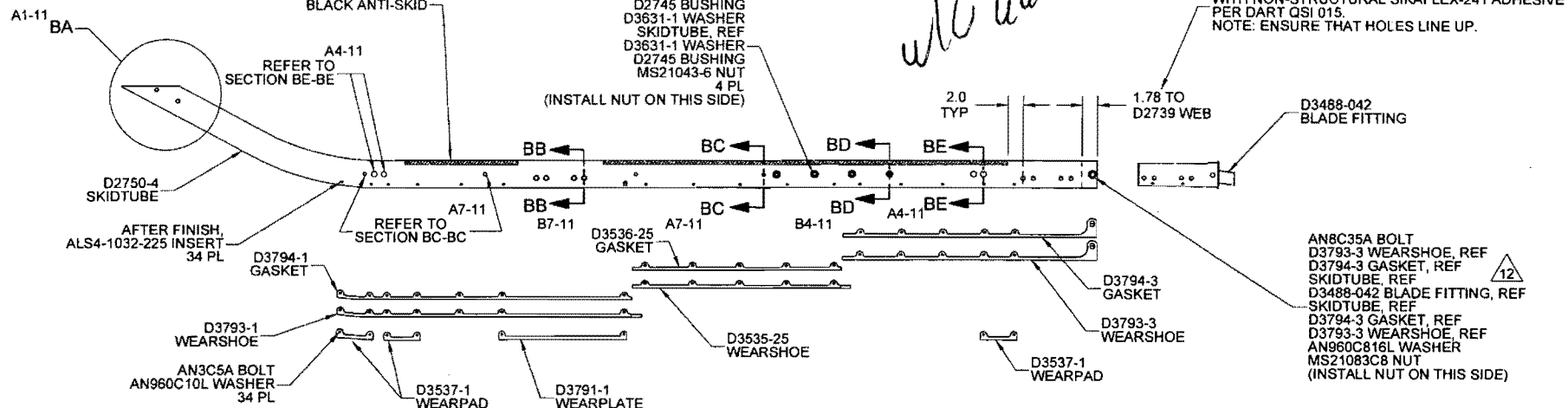
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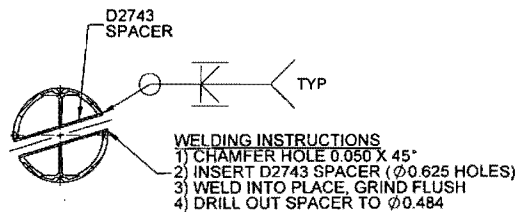
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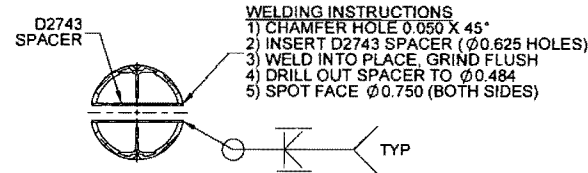




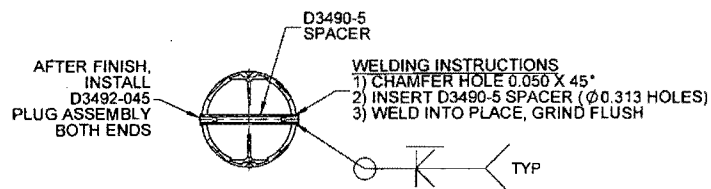
D2750-044 350 SKIDTUBE ASSEMBLY, RH



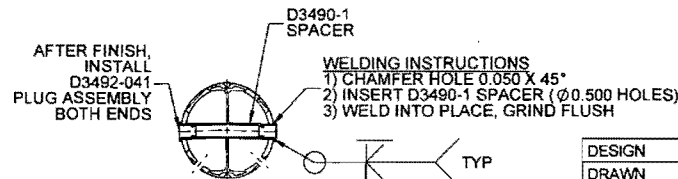
SECTION BB-BB
SCALE 3X, 4 PL



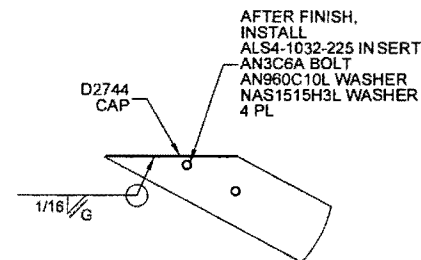
SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL



DETAIL BA
SCALE 2X

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08-07-22 / 11/16

NO. 243

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barkley Elliott
Job number: ~~64953~~ 64953
Part number: J350-636-016
Description: 350 skid tube
Welding Process: Tig[☒] Mig[],
Base material: Aluminum
Current: AC[] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Jac. [Signature] Date of Test Coupon 11-01-18

Welder Barkley Elliott Date of Test Coupon 11-01-18

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

